

# Work Order ID 63349

Wednesday, October 27, 2010 4:02:59 PM



Page 1

Item ID: D350-607-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Lid Opener Installation

Start Date: 10/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date: 10-10-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr   | Revision Nbr |
|------------|--------------|
| D350-607-1 | A            |

100 0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D350-607-143  
CHG001

0.00

*S1011103*

*J. Brigitte 10/11/02*

110 Pick Kit 0.00



Packaging

Packaging

Memo

0.00

*10/11/02 (1)*

120 QC4- 100% Inspect kits for completeness 0.00



QC

Quality Control

Memo

0.00

*S1011103*

*(70)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 63349**

Wednesday, October 27, 2010 4:02:59 PM

Page 2

Item ID: D350-607-143

Accept

Setup Start

Revision ID:

Stop

Item Name: Automatic Lid Opener Installation

Start Date: 10/27/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-143

Location: \_\_\_\_\_  
PPP rev: A

140

0.00



QC

Memo

Quality Control

QC21- Final Inspection - Work Order Release

10/11/3 110/11/03 MFMF  
10-11-3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Wednesday, October 27, 2010 4:03:03 PM

Work Order ID: 63349

Parent Item: D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 10/27/2010





Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revC DD 10.01.18 verified by:EC  
545 DD 10.04.19 verified by:EC

IPP RevB: as  
IPP RevC: as per ecn10-

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit     | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D3953-7<br><br>Spring Spacer           |                        | Manufactured  | No          |                     |                  | 110             | Each               | 6.0000         | 1               | 1            |               |                |        |
|  |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|  |                        |               |             | ST103               |                  |                 | 6                  |                |                 |              |               |                |        |
|  |                        |               |             | 59438               |                  |                 | 6                  |                |                 | 59438        |               |                |        |
| D3953-3<br><br>Gas Spring Stud, Lid    |                        | Manufactured  | No          |                     |                  | 110             | Each               | 6.0000         | 1               | 1            |               |                |        |
|  |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|  |                        |               |             | ST102               |                  |                 | 6                  |                |                 |              |               |                |        |
|  |                        |               |             | 59437               |                  |                 | 6                  |                |                 | 59437        |               |                |        |
| D3953-5<br><br>Gas Spring Stud, Base |                        | Manufactured  | No          |                     |                  | 110             | Each               | 15.0000        | 1               | 1            |               |                |        |
|  |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|  |                        |               |             | ST101               |                  |                 | 15                 |                |                 |              |               |                |        |
|  |                        |               |             | 53758               |                  |                 | 15                 |                |                 | 53758        |               |                |        |
| D3953-9<br><br>Gas Spring Washer     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 10.0000        | 2               | 2            |               |                |        |
|  |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|  |                        |               |             | ST103               |                  |                 | 10                 |                |                 |              |               |                |        |
|  |                        |               |             | 60008               |                  |                 | 10                 |                |                 | 60008        |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, October 27, 2010 4:03:04 PM

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Work Order ID: 63349

Parent Item: D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C11A

Purchased

No

110

Each

36.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST351

36

112969

36

AN3C13A

Purchased

No

110

Each

54.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST352

54

112255

4

112969

50

AN310-4

Purchased

No

110

Each

40.0000

2

2



NUT

Location

Loc Qty

Loc Code

ST324

40

115107

20

115936

20

MS21043-3

Purchased

No

110

Each

2,506.000

4

4



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2430

112314

2430

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                           |
|------|------|--------------------|----|------|-----|-------------------------------------|---------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval,<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                           |
|      |      |                    |    |      |     |                                     |                           |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 4:03:04 PM

Page 4

Work Order ID: 63349

Parent Item: D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

MS24665-2-12 Purchased No

110 Each

89.0000

2

2



COTTER PIN

Location

Loc Qty

Loc Code

ST309

89

111499

89

110

Each

4,105.000

4

4

NAS1149C0332R

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST297

4105

113524

10

113737

150

114341

26

115000

125

115698

78

115816

194

115832

3522

110

Each

662.0000

2

2

NAS1149C0432R\*

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST297

662

114292

72

114742

590

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

## 6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

| Qty<br>-141 | Qty<br>-143 | Qty<br>-145 | Part Number   | Description   |
|-------------|-------------|-------------|---------------|---|
| X           |             |             | D350-607-141  | AUTOMATIC LID OPENER INSTL<br>(FOR USE ON -041 BASKET)      |
|             | X           |             | D350-607-143  | AUTOMATIC LID OPENER INSTL<br>(FOR USE ON -043/-047 BASKET) |
|             |             | X           | D350-607-145  | AUTOMATIC LID OPENER INSTL<br>(FOR USE ON -045 BASKET)      |
| 2           |             | 1           | D3953-1       | GAS SPRING BRACKET  |
| 2           | 1           | 1           | D3953-3       | GAS SPRING STUD (LID)                                       |
| 2           | 1           | 1           | D3953-5       | GAS SPRING STUD (BASE)                                      |
| 2           | 1           | 1           | D3953-7       | GAS SPRING SPACER   |
| 4           | 2           | 2           | D3953-9       | GAS SPRING WASHER   |
| 2           | 1           | 1           | D3953-11      | GAS SPRING SPACER   |
| 2           |             | 1           | D3953-13      | GAS SPRING SPACER   |
|             | 1           |             | D3953-15      | GAS SPRING BRACKET  |
|             | 1           |             | D3953-17      | GAS SPRING SPACER   |
| 2           | 1           | 1           | D3969-1       | GAS SPRING  |
| 4           | 2           | 2           | AN3C11A       | BOLT  |
|             | 2           |             | AN3C15A       | BOLT  |
| 4           |             | 2           | AN3C16A       | BOLT  |
| 4           | 2           | 2           | AN310-4       | CASTELLATED NUT   |
| 8           | 4           | 4           | MS21043-3     | NUT   |
| 4           | 2           | 2           | MS24665-212   | COTTER PIN  |
| 8           | 4           | 4           | NAS1149C0332R | WASHER (OR AN960C10L)                                       |
| 4           | 2           | 2           | NAS1149C0432R | WASHER (OR AN960C416L)                                      |